

GREEN

Dart Aerospace Ltd.

Date: Wednesday, 9/6/2006 3:53:23 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG		
Job Number	28452	Part Number	: D25941		
Estimate Number	10178	Drawing Number	: D2594 REV B1		
P.O. Number	N/A	Project Number	: N/A		
This Issue	9/6/2006	S.O. No.	: 10178		
Prsht Rev.	NC	Type	: MACHINED PARTS		
First Issue	N/A	Material	: N/A		
Previous Run	28014	Due Date	: 9/30/2006		
Written By	: <i>John Johnston</i>				
Checked & Approved By	: <i>John Johnston</i>				
Comment	: Est D 02.08.02 Make in Cobra KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0625	6061-T6 Round Bar .625"
Comment: Qty.: 0.0547 f(s)/Unit Total : 5.2517 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625) Batch <i>101421-75.2517</i> <i>John Johnston 09.08.96</i>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max. <i>John Johnston 09.08.96</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>John Johnston 09.08.96</i>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>John Johnston 09.08.96</i>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 <i>John Johnston 09.08.96</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA  Date: 06/10/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat GREEN (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

06/06/02

96

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 10 02

96

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/03

96

Job Completion



U 06/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28452
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>[Signature]</i>	Audited by:	<i>MB</i>	Prototype Approval:	N/A
Date:	06-09-07	Date:	<i>ad gal01</i>	Date:	<i>MS</i>

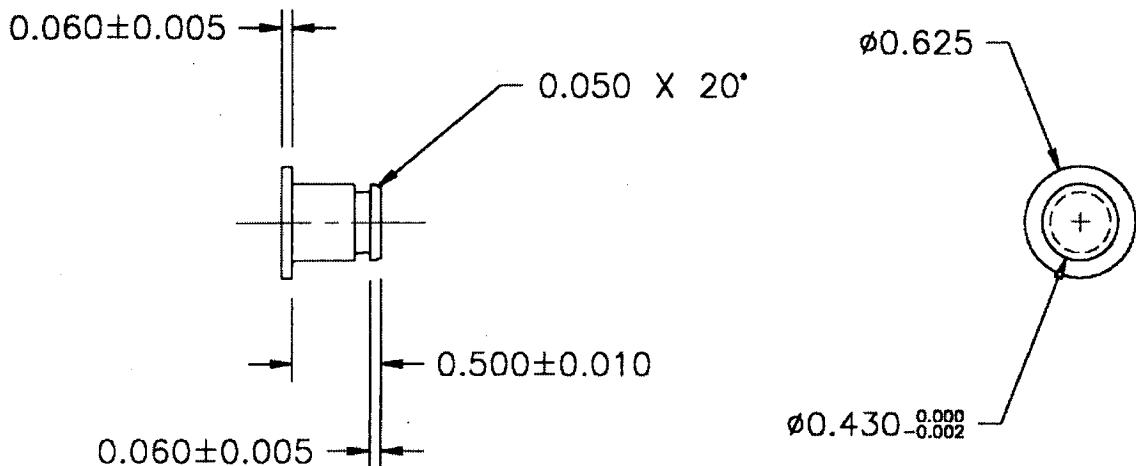
Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	PP



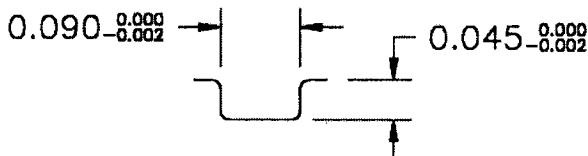
DESIGN <i>DMY</i>	DRAWN BY <i>DMY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>DMY</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	RF 02.08.26	ADD Powder coat, QSF 018, & QQ-A SPES.	

D2594-1 PLUG:

RELEASED
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



TOLERANCES ARE PER DART QSF 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

FINISH: ACID ETCH, ALODINE

Powder coat white (REF. 43.5.1) PER QSI 005 4.3

B1

PER QQ-A-225 /7 (5052)
OR QQ-A-225 /8 (6061)
OR QQ-A-225 /1 (1100)
OR QQ-A-200 /8 (6061)

B1

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH
(PARKER 2-011)

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

D2594 PLUG ASSEMBLY INCLUDES: (1) D2594-1 PLUG WITHOUT NOTICE
(1) D2594-3 O-RING WORK ORDER NO: *28452*